



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-143
Job Sheet 171260



Part No: D205-634-143

Job Qty: 2 ea

Part Name: Run-on Landing Wearplate 205 / 210 / 212 / 214 / 412 / UH-1H



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV I SHEET 12 IPP revA 11.09.26 new issue EC verified by:DD IPP REV:B 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier			Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	2 Ea		2/9/18	0.00	0.00	Start Up Stores/Pkg-1			FEB 06 2018
110	Packaging	2 pcs		2/9/18	0.00	0.00	Packaging1-2			FEB 21 2018
120	QC	2 pcs		2/9/18	0.00	0.00	QC4			Smb
125	DC	2 pcs		2/9/18	0.00	0.00	DC			
130	Packaging	2 pcs		2/9/18	0.00	0.00	Packaging3-1			Smb
140	QC21-FG	2 Ea		2/9/18	0.00	0.00	QC21			DAS

Part Op 125 - Photocopy bluefile & type labels per PPP D205-634-143
Descriptions: 130 - Identify and pack for shipping as per PPP D205-634-143

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-45A	Bolt	16 Ea (8 ea)	90-Start up Operation	
D2570	Bushing	32 Ea (16 ea)	90-Start up Operation	
D2579	Crossbolt Spacer	8 Ea (4 ea)	90-Start up Operation	
D4406-041	Fwd Wearplate Assembly	2 Ea (1 ea)	90-Start up Operation	
D4406-043	Aft Wearplate Assembly	2 Ea (1 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-45A	16	76	0
	D2570	32	420	0
	D2579	8	18	0
	D4406-041	2	2	0
	D4406-043	2	0	0
	MS21042L4	16	2,470	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date: _____

AGAINST DEPARTMENT/PROCESS

 Skid-tube
Machining

 Cross tube
Small Fab
Finishing
Composite

 Water Jet
Prod. Eng. Coord.
Rec/Store/Packaging
Supplier

 Engineering
Quality
Other

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART AEROSPACE
S039569
Run - on Landing Wearplate 205 / 210 / 212 / 214 / 412 /
UH - 1H
PART NO:
Original Serial #: D205 - 634 - 143
Revision:
Operation:
Change No: S039569
Start up Operation 02/06/18
CHG003
Job No: 171260

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

OTHER: _____

CATEGORY

Power Loss/Surge	☐	Positioned Wrong	☐
Folio/Program	☐	Outside Dimensions	☐
Grain	☐	Over/Under tolerance	☐
Weld	☐	Part Incorrect	☐
Wrong Stock Pulled	☐	Part Lost/Missing	☐
Out of Sequence	☐	Part Moved	☐
Off-set	☐	Drawing	☐
Mislabeled	☐	Finish	☐
Fit/Function	☐	Misread	☐
Misaligned/off center	☐	Turning Sequence	☐



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Master Unit 000555

Containers on Master Unit 000555				
Serial No	Part No	Customer Part No	Status	Quantity
F135979	AN4-45A		Allocated	10
S039563	AN4-45A		Allocated	6
S002026	D2570	D2570	Allocated	1
S039562	D2570	D2570	Allocated	31
S039565	D2579	D2579	Allocated	8
S018138	D4406-041		Allocated	2
S039560	MS21042L4	MS21042L4	Allocated	16

D4406-041

SO 44223

D4406-04B

SO 44212

5.2 Skidtube Installations with Training Thru-Bolt Wearplates

Item	634 -111	634 -141	634 -143	641 -011	Part Number	Description
	X				D205-634-111	SKIDTUBE INSTALLATION (STANDARD) WITH TRAINING WEARPLATE
	1	X			D205-634-141	REPLACEMENT SKIDTUBE WITH TRAINING WEARPLATE
			X		D205-634-143	TRAINING WEARPLATE KIT
	1			X	D205-641-011	GROUND HANDLING KIT
1.		1			D2580-047	205 SKIDTUBE ASSEMBLY (STANDARD)
2A		8			D2594-1	* PLUG
2B		8			D2594-3	* O-RING
3		1			D2855	* AFT CAP
4		2			AN3-5A	* BOLT
5		2			NAS1149D0332J	* WASHER (AN960JD10L)
13		2			ALS4-1032-225	* INSERT
14A		1	1		D4406-041	* FWD WEARPLATE ASSEMBLY
15A		1	1		D4406-043	* AFT WEARPLATE ASSEMBLY
16		8	8		AN4-45A	* BOLT
17		16	16		D2570	* BUSHING
18		8	8		MS21042L4	* NUT (OR MS21042-4)
19			4		D2579	* SPACER
20	1				D2571	SADDLE, FWD OUTSIDE
21	1				D2572	SADDLE, FWD INSIDE
22	1				D2573	SADDLE, AFT OUTSIDE
23	1				D2574	SADDLE, AFT INSIDE
24	8				AN4-51A	BOLT
25	16				D2570	BUSHINGS
26	8				MS21042L4	NUT (OR MS21042-4)
27	8				AN6-12A	BOLT
28	8				NAS1149D0668J	WASHER (AN960JD616)
29	16				AN4-6A	BOLT
30	32				NAS1149D0463J	WASHER (AN960JD416)
31	16				MS21042L4	NUT (OR MS21042-4)
32	4				D2747	SET SCREW
33	2				D3533-1	SET SCREW
40	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1				D3456-1	WASHER
43	1				MS21043-4	NUT
44	2				D3417-5	WASHER
50				1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51				1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52				4	AN4C46A	BOLT
53				8	D2570	BUSHING
54				4	MS21043-4	NUT (OR MS21042-4)
60	2				D2876	SADDLE SPACER
61	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-047 ASSEMBLY ABOVE

PAGE 1 OF 1

Description: TRAINING WEARPLATE

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					